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RB KIT 407M-13
Job Sheet 200979



Part No: RB KIT 407M-13

Job Qty: 10 pcs

Part Name: Gauge Pin .1080" dia.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Due Date: 10/14/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RB KIT 407M REV.D IPP REV A 18.01.29 NEW ISSUE RQ VERIFIED BY DP/IPP Rev B 18.03.08 DWG update Rev. C DP Verify DD/IPP Rev. C 19.01.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	10 pcs	10/14/19		0.00	2.00	Small Fab - 1		
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
120	QC 5	10 pcs	10/14/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	10 pcs	10/14/19		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		

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				Packaging 3 - 4 - B4B		DAS 28 9-89	
				Packaging 3 - 5 - B4B			
				Packaging 3 - 6 - B4B			
				Packaging 3 - 7 - B4B			
				Packaging 3 - 8 - B4B			
				Packaging 3 - 9 - B4B			
				Packaging 3 - 10 - B4B			
				Packaging 3 - 11 - B4B			
				Packaging 3 - 12 - B4B			
				Packaging 3 - 13 - B4B			
				Packaging 3 - 14 - B4B			
				Packaging 3 - 15 - B4B			
				Packaging 3 - 16 - B4B			
				Packaging 3 - 17 - B4B			
				Packaging 3 - 18 - B4B			
				Packaging 3 - 19 - B4B			
				Packaging 3 - 20 - B4B			
				Packaging 3 - 21 - B4B			
				Packaging 3 - 22 - B4B			
				Packaging 3 - 23 - B4B			
				Packaging 3 - 24 - B4B			
				Packaging 3 - 25 - B4B			
				Packaging 3 - 26 - B4B			
				Packaging 3 - 27 - B4B			
				Packaging 3 - 28 - B4B			
				Packaging 3 - 29 - B4B			
				Packaging 3 - 30 - B4B			
				Packaging 3 - 31 - B4B			
				Packaging 3 - 32 - B4B			
				Packaging 3 - 33 - B4B			
				Packaging 3 - 34 - B4B			
				Packaging 3 - 35 - B4B			
				Packaging 3 - 36 - B4B			
140	QC 21 - SA	10 pcs	10/14/19	0.00 0.00	QC 21 - SA - 21		DAS 21 9-89
					QC 21 - SA - 70		
					QC 21 - SA - 53		

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Part Op 100 - 1-Cut pin in half. 2-Deburr 3-Put pin in small sealable plastic bag with a small amount of LPS 2 to prevent corrosion.
 Descriptions: 4-Package as per note 10.
 120 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
21135A54	Plug Gauge	5 Ea (.5 ea)	100-Small Fab - 1	5151 993

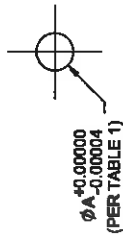
Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	21135A54	5	71	0

Part Specifications

Specifications could not be found.

Plex 9/20/19 9:49 AM Dart.lajeunesse.marie



**TABLE 1
GAUGE PIN DIMENSIONS**

PART NUMBER	ϕA	B	PURCHASE PART NUMBER (No MASTER CARR)
RB KIT 407M-01	$\phi .02400$	1.00"	21135A52 OR EQUIV.
RB KIT 407M-03	$\phi .04000$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-05	$\phi .05400$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-07	$\phi .08000$	1.00"	21135A53 OR EQUIV.
RB KIT 407M-09	$\phi .08000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-11	$\phi .09600$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-13	$\phi .10800$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-15	$\phi .12000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-17	$\phi .14400$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-19	$\phi .14400$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-21	$\phi .18000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-23	$\phi .18000$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-25	$\phi .17280$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-27	$\phi .17280$	0.25"	21135A54 OR EQUIV.
RB KIT 407M-29	$\phi .18000$	1.00"	21135A54 OR EQUIV.
RB KIT 407M-31	$\phi .19200$	1.00"	21135A55 OR EQUIV.

RB KIT 407M-01 THRU -31 ϕ .XXXX, CLASS X PLUG NO-GO GAUGE

NOTES:
1) MATERIAL: SEE TABLE 1 FOR MATERIAL SPECIFICATION
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: XX = $\pm 0.1"$ / $\pm 1"$
XX = $\pm 0.01"$ / $\pm 0.5"$
XXXX = $\pm 0.005"$ / $\pm 0.1"$
XXXX = $\pm 0.0005"$ / $\pm 0.05"$

5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) BREAK SHARP EDGES: N/A
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD
DRAWN	MBB	HAWKESBURY, ONTARIO, CANADA
CHECKED	KPT	TOOL PART #
MFG. APPR.	DP	RB KIT 407M
APPROVED	VP	TITLE
DATE	1/17/2019	SPLINE MEASURING KIT
		REV. D
		SHEET 3 OF 9
		SCALE
		NTS

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1909-20



Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

DEPARTMENT/PROCESS

DISPOSITION

Job: _____	Skid-tube Machining	Cross tube	Eng. (Non-AW)	Engineering
Part No. _____	Large Fab	Small Fab	Prod. Eng. Coord.	Water Jet
		Finishing	Rec/Store/Packaging	Supplier
				Quality

MRB (QS1042)

QTY Affected :

Sequence #:

Disposition

Description Work Order Deviation

Completed By

Lead hand / Supervisor

QC / QA Coordinator

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Root Cause

Operator
Manufacturing Process
Equip/Tooling
Handling/Preservation
Material
Product Improvement
Process Improvement
Human Factors

Other/Details: